

ship Dec 9 or sooner

Work Order ID 76649

76649

Page 1

November-18-11 10:39:04 AM

Item ID: D3267-043 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Basket Lid Assembly (Inside)
Start Date: 18/11/2011 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 09/12/2011 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: M.L.J Date: 11/11/18 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3267	Rev C

100 Weld per dwg A/R S.S. rod Batch: 4115378 0.00
Large Fab
Memo 0.00
Large Fab
1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267
2-Cut (4) D2236-1 From D3166-3
3-Drill holes in tubing D3267-043 as per Dwg D3267
4-Deburr & Remove All Markings From Material
5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required
Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

1x 11/12/09

PC 11.12.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

76649

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 18/11/2011 **Start Qty:** 1.00

*** 1 ***

Required Date: 09/12/2011 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Memo

0.00

Quality Control

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

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 Revision ID:
 Item Name: Basket Lid Assembly (Inside) Stop ***NS2***
 Start Date: 18/11/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 09/12/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

130

Powdercoat

Powder Coating

Memo

0.00

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST

START TIME: 1:00

OVEN TEMPERATURE: 400 OF

FINISH TIME: 1:30

***** 2nd coat if necessary *****

2ND COAT:

START TIME: 1:45

OVEN TEMPERATURE: 400

FINISH TIME: 2:15

140

QC3- Inspect Part Finish

0.00

140

QC

Quality Control

Memo

0.00

1X of m-f 11/12/09

m11a480

11/12/09

Dart Aerospace Ltd

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Basket Lid Assembly (Inside)

Stop ***NS2***

Start Date: 18/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 09/12/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145	Identify as per dwg & Stock Location: _____	0.00							
145									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

u 11.12.09

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November-18-11 10:39:09 AM

Work Order ID: 76649

76649

Parent Item: D3267-043

D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:C Removed -041 05-11-04 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC
IPP Rev:E add I.D. DD 10.03.11 verified by:EC IPP Rev:F
reverse order of seq. 150, 155 DD 10.04.07 Verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3		Manufactured	No			100	Each	6.0727	0	0			
D3166-3													
Basket Hoop													

Location	Loc Qty	Loc Code
WA	6	
73627	6	
WA007	0.07270527	
64928	0.02010527	
68442	0.0526	

D3182-1		Manufactured	No			100	Each	6.0000	2	2			
D3182-1													
Hinge													

Location	Loc Qty	Loc Code
WA	6	
71223	6	

D3442-3		Manufactured	No			100	Each	11.0000	2	2			
D3442-3													
Shim													

Location	Loc Qty	Loc Code
WA005	11	
70671	11	

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Page 2

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Parent Item: D3267-043

D3267-043

Parent Item Name: Basket Lid Assembly (Inside)

Start Date: 18/11/2011

Required Date: 09/12/2011

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

506.7499

7

7.368421

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

11/12/08

Location

Loc Qty

Loc Code

MAT018

485.0857585

117636

67.9987

118773

417.087059

WA

6.0667

118181

6.0667

WA007

15.5974906

116267

14.628472

116763

0.9690186

7.36

M304EX0.75-16F

Purchased

No

110

sf

554.2561

4.3

4.526316

M304FX0 75-16F

Expanded Metal Flat SS

**

11.12.08

Location

Loc Qty

Loc Code

WA

554.2561116

117197

102.9036

117896

53.3264

118153

76.8473

118248

33.0983

118597

21.06788

118955

82.17

119180

184.842632

4.5263

Dart Aerospace Ltd

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76649 M.L.J
11/11/18

RELEASED
08-09-18



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3267	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET LID ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

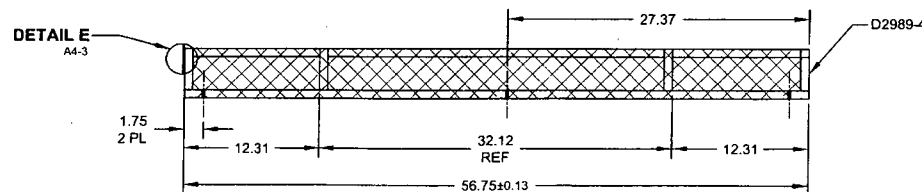
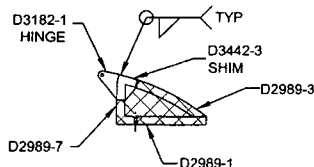
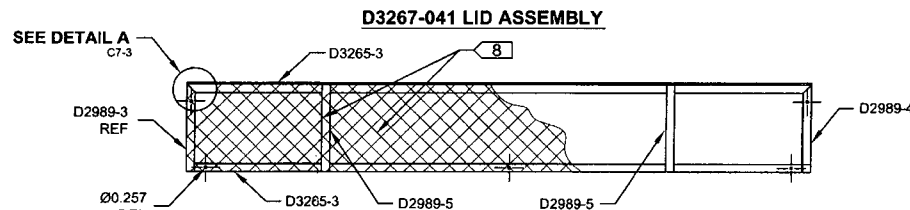
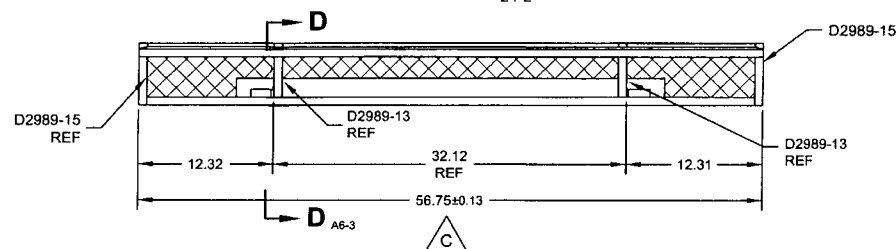
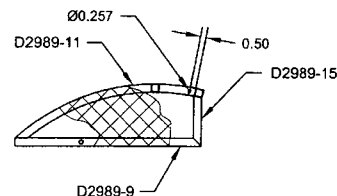
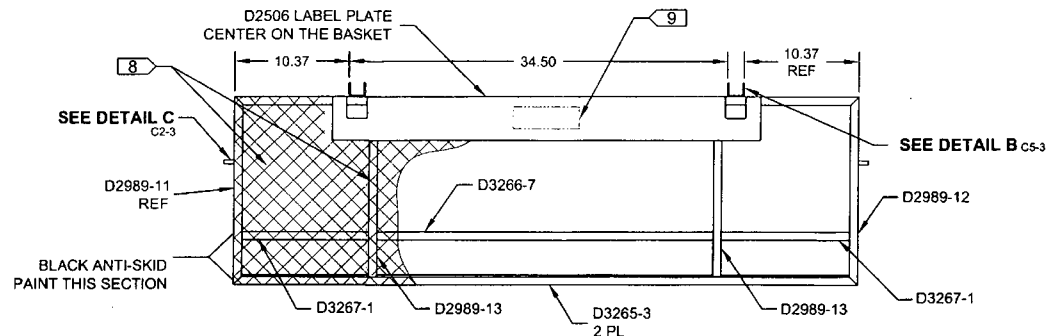
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NOTE: Date & initial all entries

76649



NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

RELEASED
08.07.04/10

D3267-041 LID ASSEMBLY

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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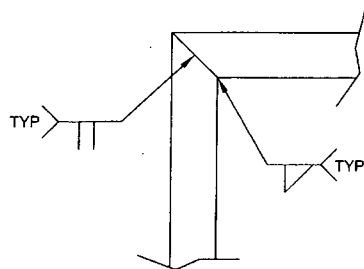
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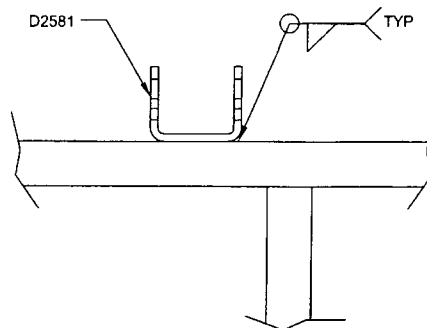
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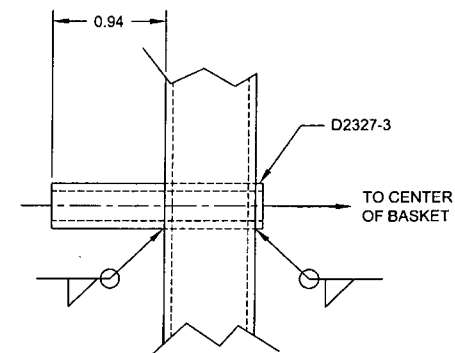
76649



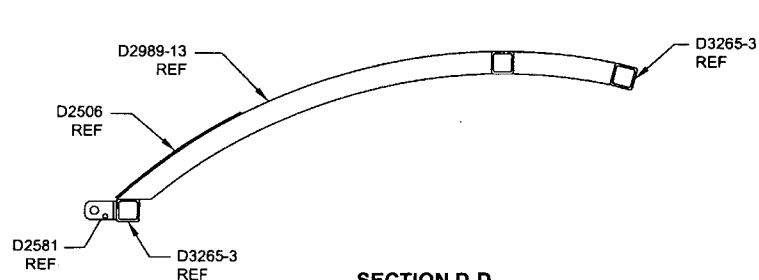
DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X



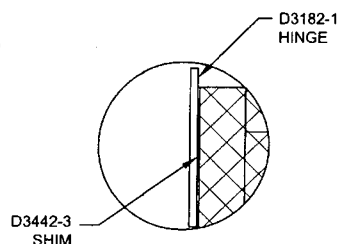
DETAIL B D2-2
2 PL
SCALE 2X



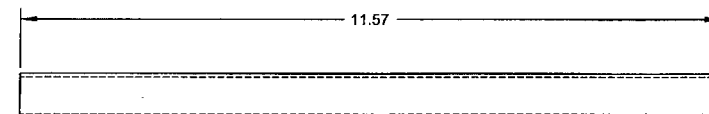
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

RELEASED
08-07-11

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	3 OF 3
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